

Work Order ID 108481-2

October-17-13 1:35:37 PM

Item ID: D2803-042

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/17/13 Start Qty: 4.00

Required Date: 10/17/13 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MJS

QC:

Date: 13-10-21

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

100

Small Fab

Small Fab

Small Fab

Memo

Press D2805-2 and D2809 into arm as per Dwg D2803

0.00

0.00

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

120

120

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

108481

Page 1

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

D2803-042
B108481

4

4

3x

14/03/18
DAS 36 9-89

DAS 27 9-89

14/3/18

3

11/12/07

3 14-3-18

DAS 34 9-89

100
100

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Start Date: 10/17/13 Start Qty: 4.00

Required Date: 10/17/13 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Memo

150

150

Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D2803.

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

108481

Page 2

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Tooling:

Date:

Run Start ***NR1***

Stop ***NR2***

SPC (Y/N):

Date:

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

3x

14/03/19

DAS
36
9-89

3x

14/03/19

DAS
36
9-89

3

DAS
27
9-89

14/3/19



Work Order ID 108481

October-17-13 1:35:37 PM

Item ID: D2803-042

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/17/13 Start Qty: 4.00 *4*

Required Date: 10/17/13 Req'd Qty: 4.00 *4*

Reference:

Approvals: Process Plan: Date:

QC: Date:

Sequence ID/
Work Center ID

170

170

Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: ST149

Memo

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

108481

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Set Up/
Run Hours

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

3x

DAS
28
9-89

14-03-19

PL 14-03-20

MLJ 1403-19

October-17-13 1:35:37 PM

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DAS
36
9-89

Loc Code

4

2

30

14/03/18

Loc Code

4

4

~~B107934~~ (1x)
B110030 (3x)
4/03/18
DAS
36
9-89

Loc Code

27

7

20

73 4 14/03/19 DAS 36 9-89

Loc Code

3

1

2

12

12

18

18

Picklist Print

October-17-13 1:35:37 PM

Page 2

Work Order ID: 108481

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 10/17/13

Required Date: 10/17/13

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

150

Each

1,856.0000

2

8

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

1776

124555

249

m126741

1527

100

Each

73.0000

4

16

NAS1515H3

Purchased

No

Washer

Location

Loc Qty

Loc Code

FG

4

123301

10

GA

3

124859

3

ST297

56

123301

7

125654

49

14/03/19

DAS
36
9-89

14/03/19

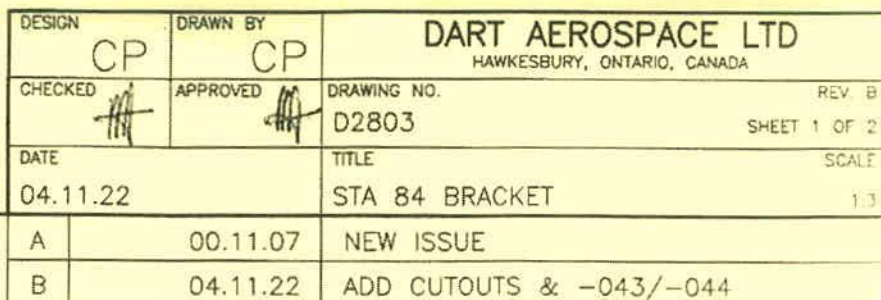
DAS
36
9-89

M127306

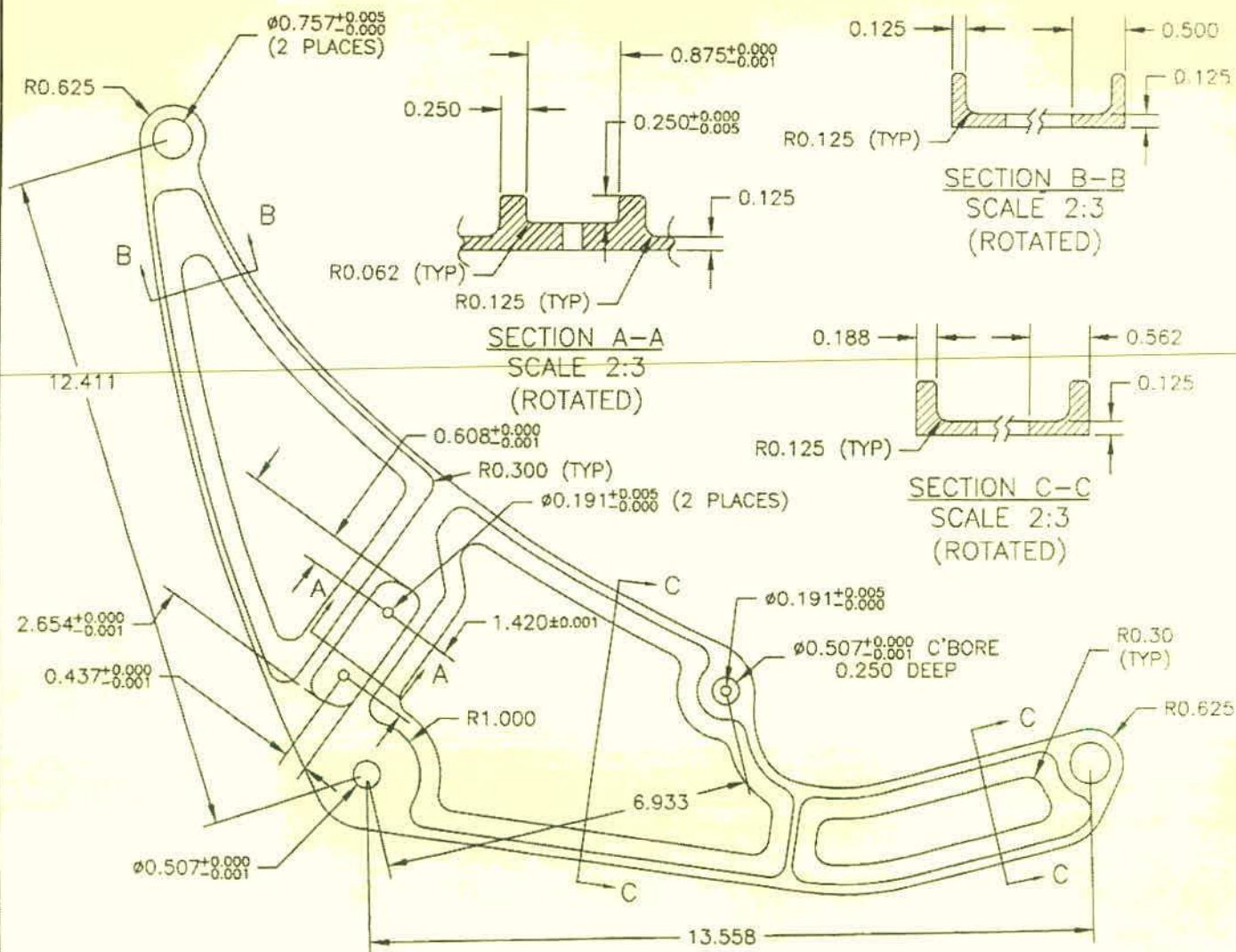
October-17-13 1:35:37 PM

Shop Packet Print

Page 2



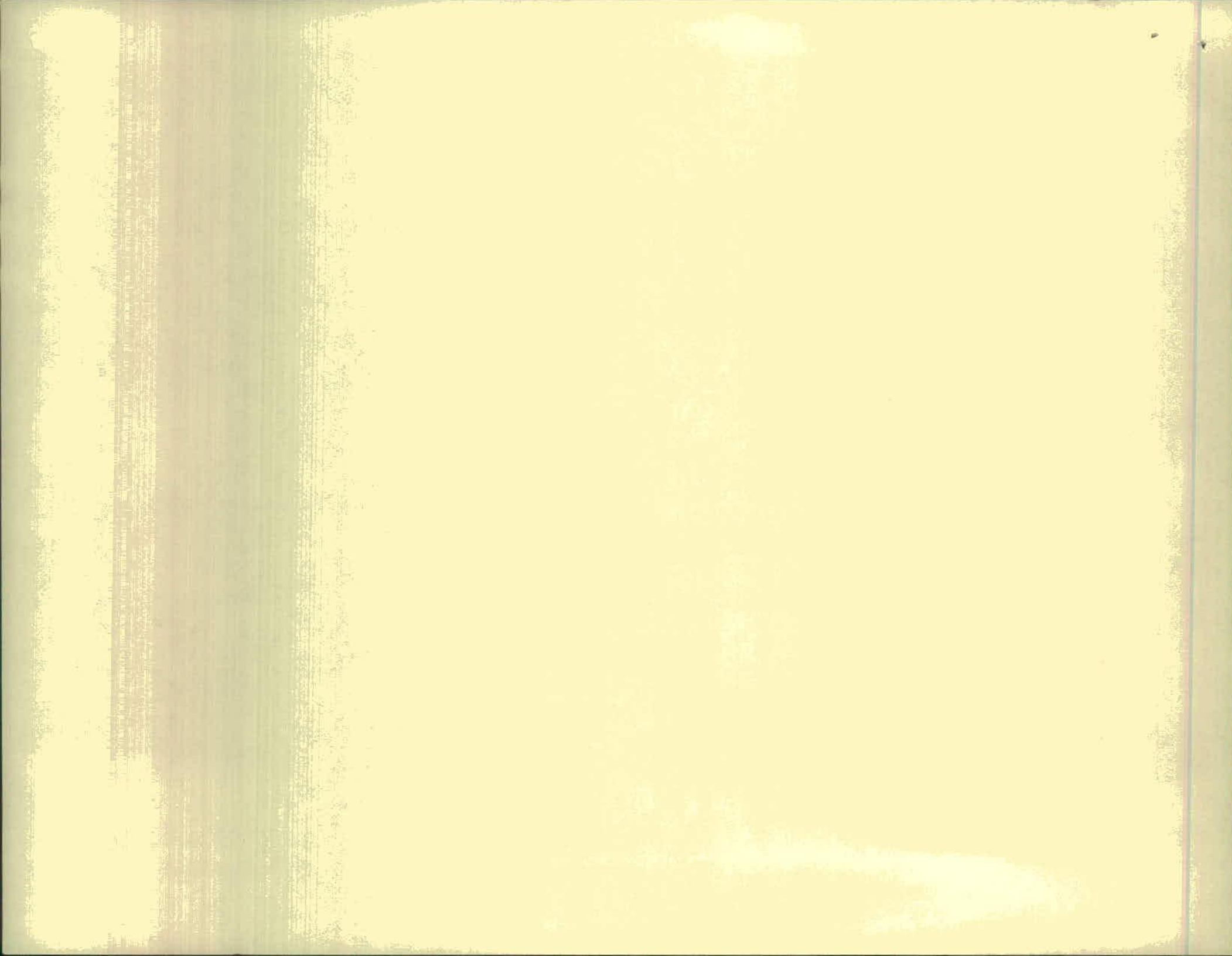
05.03.11



108481 MC2
13-10 21
THICK

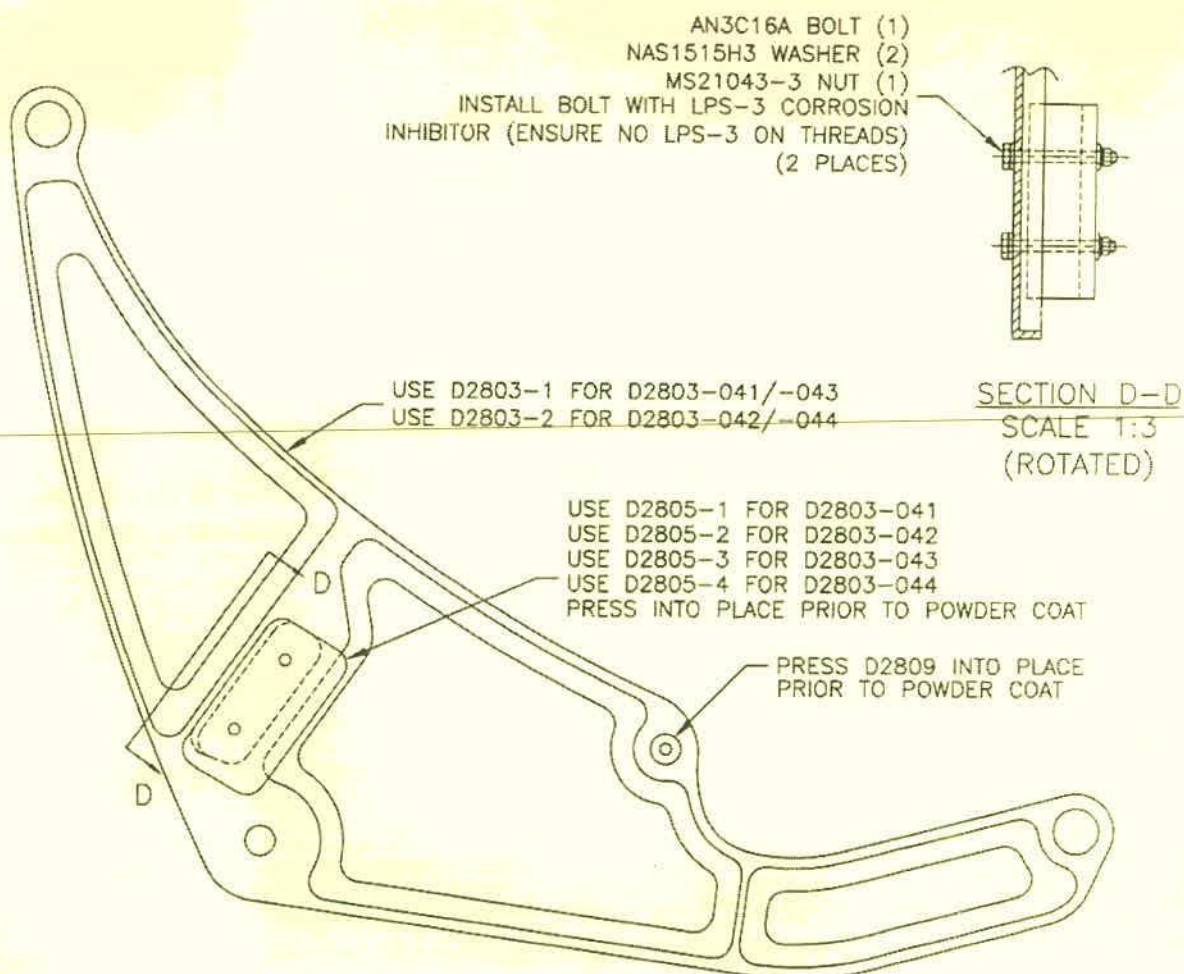
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. 8 SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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